

Date: Tuesday, 1/9/2007 4:06:59 PM  
 User: Kim Johnston

## Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : OH-58 FWD X-TUBE ASSEMBLY - UNDER REVIEW  
 Job Number : 30216  
 Estimate Number : 12526  
 P.O. Number : N/A Part Number : D058676101  
 This Issue : 1/9/2007 S.O. No. : N/A Drawing Number : D058-676-141 REV A2  
 Prsht Rev. : NC Project Number : N/A  
 First Issue : N/A Type : LANDING GEAR Drawing Revision : A2 UNDER REVIEW  
 Previous Run : 28767 Material : N/A  
 Due Date : 2/10/2007 Qty: 1 Um: Each  
 Written By :  
 Checked & Approved By :  
 Comment : Est Rev E 06.09.11 Reformat IEC

## Additional Product

Job Number:



Seq. #:

Machine Or Operation:

Description :

1.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Photocopy bluefile and create labels as per PPP D058-676-101CHG001

2.0

D6001105

Crosstube



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part number Description Batch

1 D6001-105 Crosstube B23965

3.0

MORI SEIKI

MORI SEIKI CNC LATHE LARGE



Comment: MORI SEIKI CNC LATHE LARGE

1-Fill tube with sand &amp; install plugs on both ends as per Folio FA085

2-Turn first side as per Folio FA085

3-Deburr &amp; Inspect for surface damage.

4.0

QC1

INSPECT ALL DIM TO DIM SHEET



Comment: INSPECT ALL DIM TO DIM SHEET

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Drawing Name: OH-58 FWD X-TUBE ASSEMBLY - UNDER REVIEW

Job Number: 30216

Part Number: D058676101

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

MORI SEIKI

MORI SEIKI CNC LATHE LARGE



Comment: MORI SEIKI CNC LATHE LARGE

1-Turn second side as per Folio FA085

2-Deburr & Inspect for surface damage.

MS 07/01/11

1

6.0

QC1

INSPECT ALL DIM TO DIM SHEET



Comment: INSPECT ALL DIM TO DIM SHEET

MS 07/01/11

1

7.0

QC8

SECOND CHECK



Comment: SECOND CHECK

en 07/01/15

X1

8.0

MORI SEIKI

MORI SEIKI CNC LATHE LARGE



Comment: MORI SEIKI CNC LATHE LARGE

1-Remove sand and plugs

2-Scribe part # and batch # using vibrating stylus as per Dwg D058-676-141  
Inside of Cuff(Donot engrave on outside of tube)

3G 07.01.14

1

9.0

LANDING GEAR 1

LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Polish entire outside surface of crosstube

Pmc / JD 7-1-19 ①

10.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

BE 7-1-19 ①

11.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

Pmc 7-1-22 ①

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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NOTE: Date & initial all entries

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: OH-58 FWD X-TUBE ASSEMBLY - UNDER REVIEW

Job Number: 30216

Part Number: D058676101

Job Number:



Seq. #:

Machine Or Operation:

Description :

12.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

DP 7-1-24

13.0

BENDING

BENDING MACHINE



Comment: BENDING MACHINE

Bend tube as per Dwg D058-676-141 using CNC bender program OH58-fw and Folio FT014

DP 7-1-24

14.0

QC6

DIMENSIONAL CHECK



Comment: Inspect dimensions and work To Current Step

07/02/05

15.0

LANDING GEAR 1

LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Drill pilot holes in tube as per Dwg D058-676-141 using drill Jig DT8541 & DT8542

2-Ream hole to finish size in tube as per Dwg D058-676-141 using drill Jig DT8541 & DT8542. Check dimensions between holes, both sides on both cuffs, to ensure alignment with saddle holes:

3-Deburr & Inspect for surface damage. Repair damage within limits as per Dwg D058-676-141

FT 07-02-27  
07-2-28

16.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

07-2-28

17.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

07/03/01

18.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

07-03-09  
DICKLPI

19.0

OUTSIDE SERVICE

OUTSIDE SERVICES



Comment: Sub-Contracting OUTSIDE SERVICES

Liquid Penetrant Inspection as per QSI 0380

Issue P/O: 3220

07-03-09

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: OH-58 FWD X-TUBE ASSEMBLY - UNDER REVIEW

Job Number: 30216

Part Number: D058676101

Job Number:



Seq. #:

Machine Or Operation:

Description :

LPI as per ASTM 1417 Level 2

Attach copy of NDT results to work order

20.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Inspect for transit damage Ensure copy of NDT results attached to work order

21.0

QC6

DIMENSIONAL CHECK



Comment: Inspect for damage & ensure results are as per Dwg D058-676-241

22.0

SPRAY PAINTING

SPRAY PAINTING



Comment: SPRAY PAINTING

1-Prime inside and outside crosstube as per QSI 005 4.2

ml 07 03 19

①

2-Paint outside crosstube with White Imron as per QSI 005 4.2

ml 07 03 19

①

23.0

QC14

Inspect Spray Paint



Comment: Inspect Spray Paint

Then, Wrap in plastic bag to protect from scratches

24.0

D2856400

Abrasion Strip



Comment: Qty.: 0.5800 f(s)/Unit Total : 0.5800 f(s)

Pick:

Qty Part number

Description

Batch

2 D2856-400-694 Abrasion Strip

29850

27 03-03-21

25.0

D28911

Support 2.25 dia



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part number

Description

Batch

2 D2891-1

Support

29086

27 07-03-21

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Drawing Name: OH-58 FWD X-TUBE ASSEMBLY - UNDER REVIEW

Job Number: 30216

Part Number: D058676101

Job Number:



Seq. #:

Machine Or Operation:

Description :

26.0

MS2192020

Clamp (per MIL-DTL-8783C)



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty Part number

Description Batch

4 MS21920-20

Clamp 102 440

250703-21

27.0

LANDING GEAR 1

LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Install abrasion strips as per QSI 035 using DT8579

2-Install supports and clamps as per Dwg D058-676-141. Torque clamps to 80-100 in lb.

} 250703-21

28.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

250703-21

29.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Pick Packing Kit

30.0

AN532A

Bolt



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick: Packing Kit

Qty Part number

Description Batch

4 AN5-32A

Bolt

1103338

31.0

AN960JD516

Washer



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)

Pick: Packing Kit

Qty Part number

Description Batch

8 AN960JD516

Washer

1102519

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA: ☒ Date: 07/03/23

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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Date: Tuesday, 1/9/2007 4:07:00 PM  
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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: OH-58 FWD X-TUBE ASSEMBLY - UNDER REVIEW

Job Number: 30216

Part Number: D058676101

Job Number:



Seq. #:

Machine Or Operation:

Description :

32.0

MS21042L5

Nut



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick: Packing Kit

Qty Part number

4 MS21042L5

Description Batch

Nut (or -5)

~~M20016~~

M100564

PC71

33.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

34.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D058-676-101

Location:

REV: B

PC71/03/220

SD

35.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

①  
PC71/03/223

Job Completion



U  
PC71-03-23

# Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



DESIGN <i>CP</i>	DRAWN BY <i>CP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>#</i>	APPROVED <i>#</i>	DRAWING NO. D058-676-141	REV. A SHEET 1 OF 3
DATE 00.11.17		TITLE CROSSTUBE ASS'Y (OH-58 HIGH FWD) NTS	
A	00.11.17	NEW ISSUE	

Qty	Part Number	Description
X	D058-676-141	CROSSTUBE ASSEMBLY (OH-58 HIGH FWD)
1	D6001-105	CROSSTUBE
2	D2856-400-694	ABRASION STRIP
2	D2891-1	SUPPORT
4	MS21920-20	CLAMP

#### GENERAL NOTES:

- 1) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 2) MATERIAL: MANUFACTURED FROM D6001-105  
FINISHED LENGTH = 103.03±0.020
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
PRIME INSIDE AND OUTSIDE PER DART QSI 005 4.2  
PAINT OUTSIDE PER DART QSI 005 4.2
- 4) PART IS SYMMETRIC ABOUT CENTERLINE.
- 5) RUN-OFF PART. BLEND OUT EDGE LONGITUDINALLY, TRANSITION SHOULD BE SMOOTH.
- 6) MAXIMUM TUBE FLATTENING DUE TO BENDING IS 6% BASED ON O.D.
- 7) LIQUID PENETRANT INSPECT OUTSIDE SURFACE OF CROSSTUBE PER QSI 038.
- 8) SCRIBE DART PART NUMBER AND BATCH NUMBER IN THIS AREA WITH VIBRATING STYLUS.
- 9) INSTALL D2856-400-694 ABRASION STRIP WITH A 0.13 (REF) GAP ON BOTTOM SIDE OF CROSSTUBE, CENTERED OPPOSITE D2891-1 SUPPORT, PER QSI 035.
- 10) EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE SURFACE OF THE TUBE. THE OUTSIDE SURFACE MUST BE SMOOTH AND FREE FROM SURFACE DEFECTS SUCH AS SCRATCHES, NICKS, OR DENTS. DEFECTS UP TO 0.005" MAY BE BLENDED OUT LONGITUDINALLY. CIRCUMFERENTIAL GRIND MARKS ARE UNACCEPTABLE.
- 11) SEAL EDGES OF SUPPORTS AND ABRASION STRIP USING SIKAFLEX-241/291 SEALANT.
- 12) TORQUE CLAMPS 80 TO 100 IN-LB.

**UNDER REVIEW**

*06.10.13 PH*  
*Update view 0-0*  
*07.01.09 PH*

SHOP COPY  
RETURN TO  
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UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. *30216*

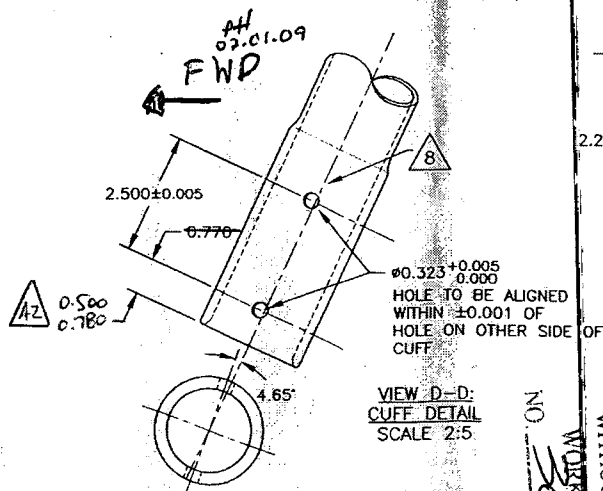
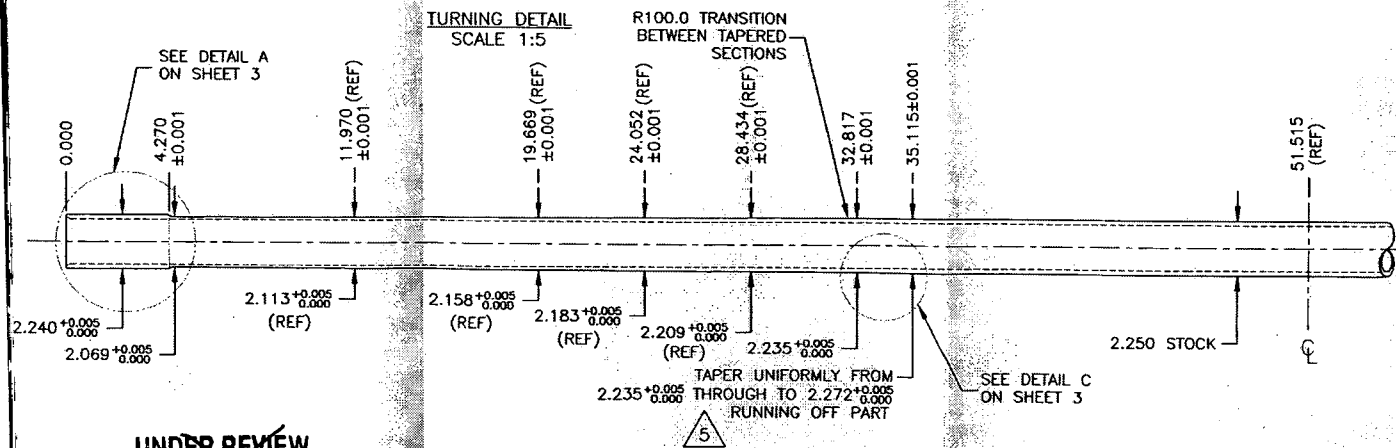
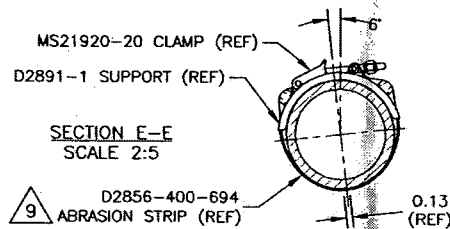
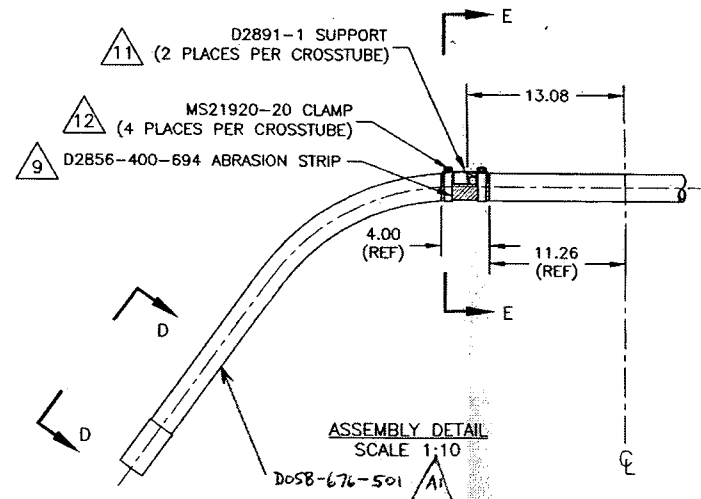
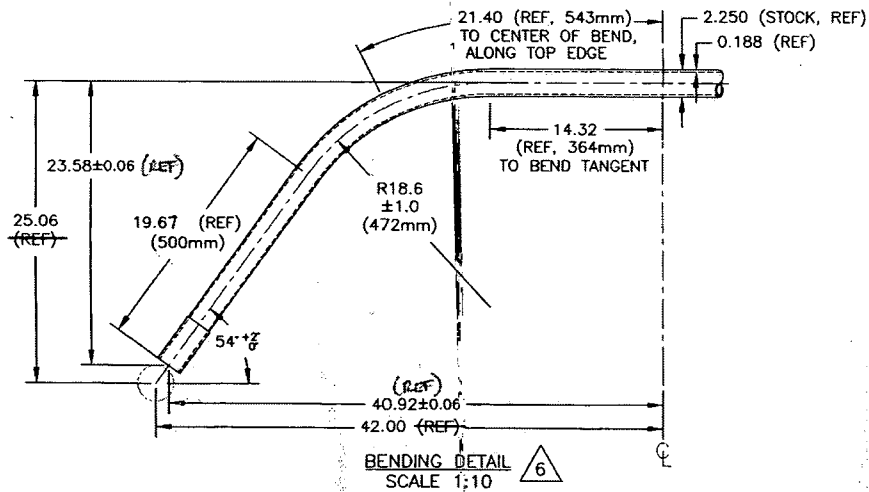
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*00.11.24 #*

A2	01.07.16	UPDATE Dim TO FIRST HOLE
A1	01.03.07	ADD D058-676-501 P/N

*# CP*  
*# CP*

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UNDER REVIEW

06.10.09 PH  
Update view 0-0

PH  
07.01.09

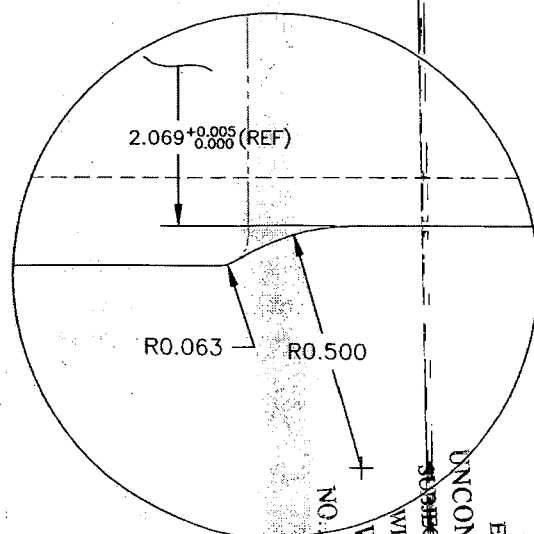
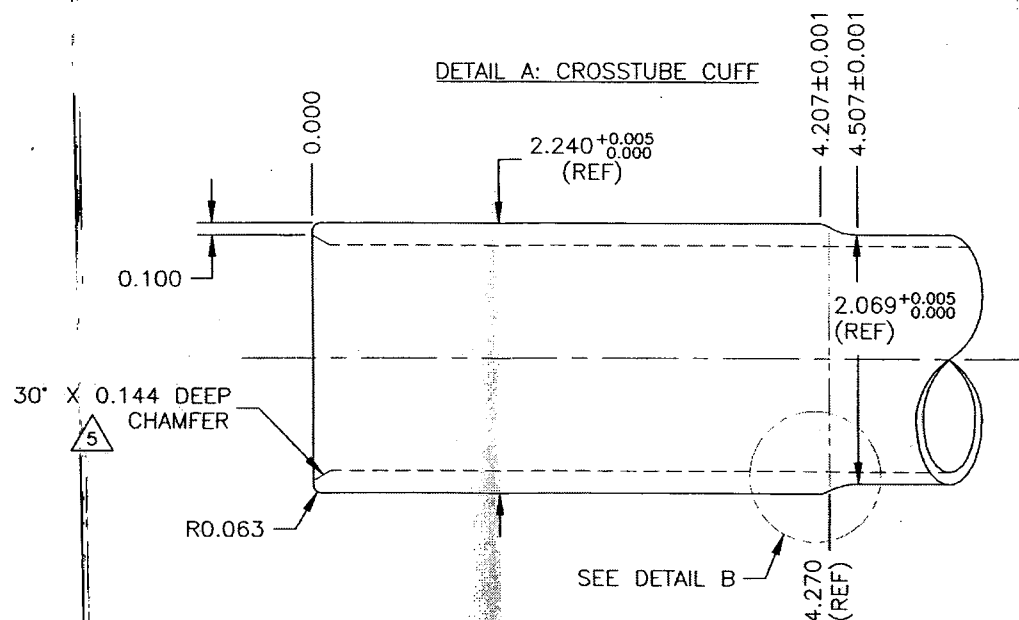
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RELEASED  
00.11.24

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		DATE	00.11.17			D058-676-141	SHEET 2 OF 3
						CROSSTUBE ASSEMBLY (04-52 HIGH FWD)	SCALE 1:10

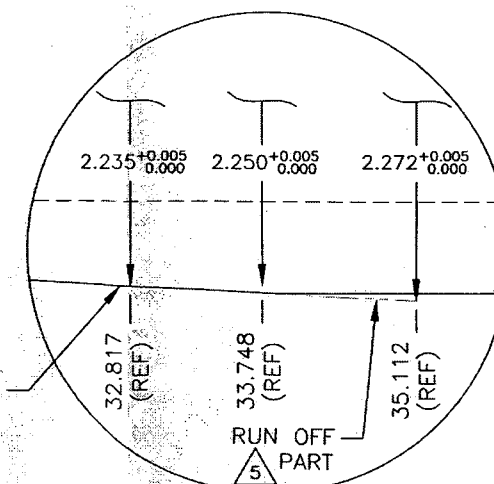
RELEASED  
00.11.24

DETAIL A: CROSSTUBE CUFF



DETAIL B:  
CUFF TRANSITION  
SCALE 4:1

DETAIL C:  
TAPER RUN-OFF  
NOT TO SCALE



UNDER REVIEW

06.10.18 RH  
update view 0-0

RH  
07.01.09

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		DATE		D058-676-141	SHEET 3 OF 3
		00.11.17		TITLE	SCALE
				CROSSTUBE ASSEMBLY (CH-53 HIGH FWD)	1:1

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b>
<b>Description:</b> Crosstube Assembly		<b>Part Number:</b> D058676101
<b>Inspection Dwg:</b> D05867614 Rev: A		<b>Page 1 of 1</b>

### FIRST ARTICLE INSPECTION CHECKLIST

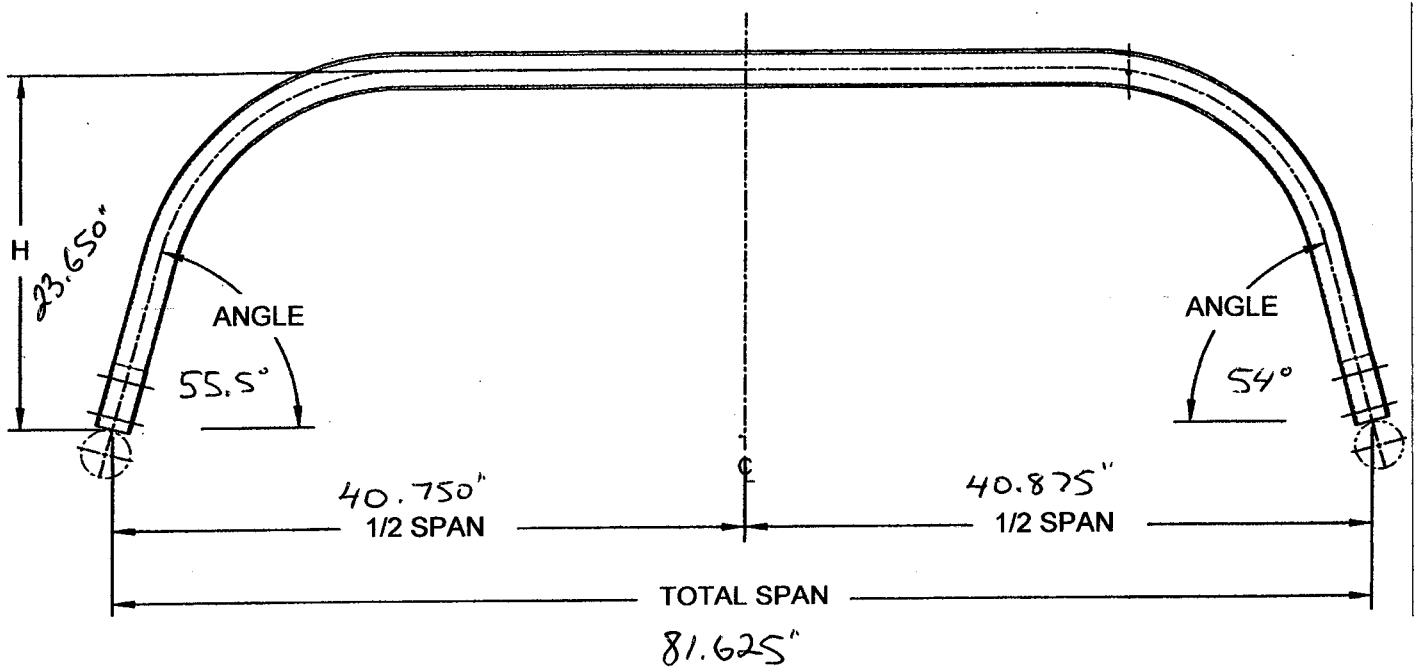
☒ First Article ☐ Prototype

Inspection Sheet Drawing Dimension		Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
SIDE A	2.240	+0.005 -0.000	2.242	✓			
	2.069	"	2.071	✓			
	2.113	"	2.115	✓			
	2.158	"	2.160	✓			
	2.183	"	2.185	✓			
	2.209	"	2.212	✓			
	2.235	"	2.238	✓			
	4.207	±.001	4.207	✓			
	R.063	±.010	.063	✓			
	R.500	"	.500	✓			
SIDE B	2.240	+0.005 -0.000	2.242	✓			
	2.069	"	2.072	✓			
	2.113	"	2.115	✓			
	2.158	"	2.160	✓			
	2.183	"	2.185	✓			
	2.209	"	2.212	✓			
	2.235	"	2.238	✓			
	4.207	±.001	4.207	✓			
	R.063	±.010	.063	✓			
	R.500	"	.500	✓			
	103.03	±.020	103.03	✓			

<b>Measured by:</b> MS	<b>Audited by:</b> EA	<b>Prototype Approval:</b>	N/A
<b>Date:</b> 07/01/15	<b>Date:</b> 07/01/15	<b>Date:</b>	N/A
<b>Rev</b>	<b>Date</b>	<b>Change</b>	<b>Revised by</b>
A		New Issue	KJ/JLM
			<b>Approved</b>



# Crosstube Bend Dimension Sheet



PART NUMBER: 1058 676 101

BATCH NUMBER: 30216

DRAWING: 1058 676 141 REVISION: A

H: 23.58

1/2 SPAN: 40.92

TOTAL SPAN: 81.84

ANGLE: 54°

QC 15: 11

DATE: 07/02/05

QTY: 1

Fit in table jig



# HeathAir

INTERNATIONAL (1991) INC.

681 Ave. Lepine, Dorval, Québec H9P 1G3  
Tél.: (514) 636-1000 • Fax: (514) 636-0031

W.O. N° 35932

A.M.O. Number: 46/90

## NON-DESTRUCTIVE TESTING REPORT

### AIRCRAFT / COMPONENT INFORMATION

REGISTRATION:

MODEL/TYPE:

SERIAL NUMBER:

TOTAL HR/LDG:

OPERATED BY:

BASED AT:

### INSPECTION REQUIREMENTS

Carry out FPI of (6) cross tubes (external surface) as per ASTM E-1417-05 and the Dart QSI 038, Section 4.1.1 (on file at client) - parts delivered to HeathAir.

Qty (6) P/N D058-676-101 S/N's B30218, B30217, B30219, B28767, B28763 and B30216

☐ RADIOGRAPHY

☐ ULTRASONIC

☒ PENETRANT

☐ MAGNETIC PARTICLE

☐ EDDY CURRENT

### INSPECTION REPORT

Fluorescent penetrant inspection was performed in accordance with the above requirements on (6) cross tubes.

Note: A Level 3 penetrant was substituted for the requested Level 2 (3 is more sensitive)  
Ardrox 970P25E Batch #04B503.

(6) cross tubes inspected. (6) PASSED / (0) FAILED.

THE MAINTENANCE DESCRIBED ABOVE HAS BEEN PERFORMED IN ACCORDANCE WITH  
THE APPLICABLE STANDARDS OF AIRWORTHINESS

INSPECTED BY:

DATE March 09, 2007

INSPECTION  
STAMP(S)

### CUSTOMER INFORMATION

CUSTOMER: Dart Aerospace

P.O. NUMBER PO 00003270

ADDRESS:

CONTACT NAME: Linda Lacelle

LABOUR

@

\$

MATERIALS

@

TRAVEL EXPENSES

@

GST

HOTEL EXPENSES

@

PST

INVOICE NO.

TOTAL \$

WHITE COPY - INSPECTION FILE • YELLOW COPY - CUSTOMER • PINK COPY - ACCOUNTANT